Date:

Thursday, 18/12/2008 12:51:04 PM

User: Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 44157

Estimate Number

: 11172

P.O. Number

Previous Run

This Issue

: 18/12/2008

Prsht Rev. : NC First Issue

: 41891

: 18/12/2008

Type

S.O. No. :

: MACHINED PARTS

Part Number

Drawing Name

: D22827

: TUBE

Drawing Number

: D2282 REV E : N/A

Project Number

Drawing Revision

Material **Due Date**

: 19/01/2009

: E

Qty:

100 Um:

Each

Checked & Approved By

Comment

Written By

: Est Rev:A

Removed from 9 Digit

05-12-02 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M304TR0675W091

304 RD Tube .675 x .091W



Comment: Qty.:

0.0699 f(s)/Unit Total:

6.9930 f(s)

Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675," OD, 0.091" wall thickness

(M304TR0.675W.091)

Batch M109364

08/12/23

100 pcs

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



2-Deburr

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA190

Mat 08/12/03



3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE







Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK





Comment: SECOND CHECK

5.0

PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Dart Aerospace Ltd

		— - 								
W/O:			WO	RK ORDER CHANG	GES	V1 -4				
DATE STEP		PRO	OCEDURE CHAN	IGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
Part No	•	PAR #:	Fault Categ	ory:	NC	R: Yes 1	No DQA	4 :	Date:	
	Re	esolution:	Disposition	:	QA	: N/C Clo	sed:		Date:	
NCR:		,	WORK ORDE	R NON-CONFORM	ANC	(NCR))			
DATE	STEP	Description of NC	Initial	Corrective Action Sec Action Description	ction B	Sign &	Verific		Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Section	on C	Chief Eng	QC Inspector
		- MacMillion and the second of			:					
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NOTE: Date & initial all entries

Date: User: 🗥

Thursday, 18/12/2008 12:51:04 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 44157

Part Number: D22827

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-24

Dart Aerospace Ltd

	. ооршоо									
W/O:			WC	ORK ORDER CHANG	E\$			-		
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					:				:	
										,
		·								
Part No	:	PAR #:	Fault Cate	gory:	_ NC	R: Yes	No DQ	A :	_ Date: _	
	Re	solution:	Dispositio	n:	_ QA	: N/C Clo	osed:		Date:	
NCR:			WORK ORD	ER NON-CONFORMA	ANCE	(NCR)			
DATE	STEP	Description of NC		Corrective Action Section	on B	C:mm 0		Verification	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
					į					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: HHIS	
Description: Handle Tube	Part Number: D228	2-7
Inspection Dwg: D2282 Rev: E	Page 1	of 1

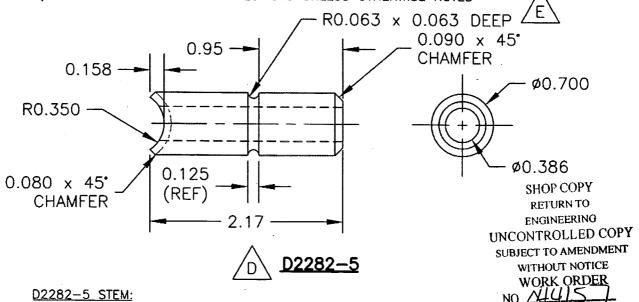
FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype							
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
0.795	+/-0.010	.795					
0.493	+/-0.010	6497					
0.675	+/-0.010	0673					
	1		<u>.</u>				
				-			
	<u> </u>						

•				_
Measured by:	Ø M	Audited by:	Prototype Approval:	N/A
Date:	08/12/23	Date: 08/12/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue P/O D350-615-041	KJ/RF	
_B	05.04.19	0.795 was 0.750	KJ/JLM	-
С	06.03.15	Dwg Rev update	KJ/JLM	
D	07.07.17	Dimensions added per Dwg Rev. E	KJ/JLM A	B

	DESIGN BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
(DLAVETT)	CHECKED	APPROVED	DRAWING NO. REV. D2282 SHEET 1 OF
	DATE	1000	U2282 SHEET 1 OF
	05.06.07		HANDLE TUBES
	Α	94.10.14	NEW ISSUE
DELXASEN	В	95.03.23	RE-DESIGN
N Q D V	С	97.10.20	CORRECTED NUMBERING SCHEME
05/09/16	D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
03/57/	Ε	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030
2.375_0.000	-	0.795	Ø0.675 (REF)
<u>D2282-3</u>	D	D2282-	Z (REF) —
D2282-3/-7 TUBE: 1) MATERIAL: T304/T316 3/ 2) BREAK ALL UMARKED SH 3) ALL DIMENSIONS ARE IN 4) TOLERANCES ARE PER D 0.9	HARP EDGES INCHES DART QSI 0	S 0.005 TO (•



1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750) 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010

3) ALL DIMENSIONS ARE IN INCHES

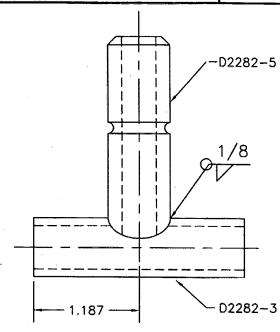
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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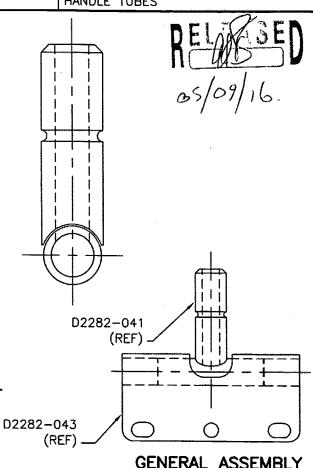
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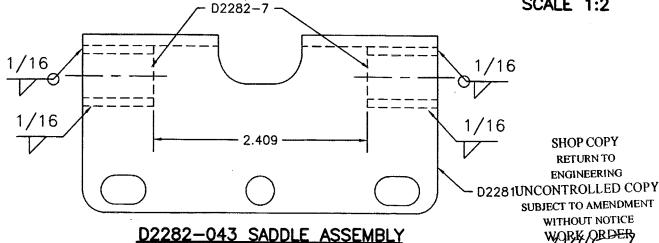
DESIGN BW	DRAWN BY	DART AEROS HAWKESBURY, ONT.	
CHECKED	APPROVED	DRAWING NO.	REV. E
u'	TUND	D2282	SHEET 2 OF 2
DATE		TITLE	SCALE
05.06.07		HANDLE TUBES	1:1



D2282-041 'T' ASSEMBLY WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY SCALE 1:2



WELD ASSEMBLY PER DART QSI 004

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